

Work Order ID 80829

80829

Page 1

March-01-12 10:09:10 AM

Item ID: D2573

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Aft Out 205

Stop *NS2*

Start Date: 01/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/01

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 80829 Double check by: OH 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-
Machine Step No 3 per Folio FA051 and insp

OH/8 12 03 05 (16)

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

OH/8 12 03 09 (x6)

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

OH/8 6 12/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

March-01-12 10:09:11 AM

Item ID: D2573

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Aft Out 205

Start Date: 01/03/2012 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7h30

OVEN TEMPERATURE:

M120222

8h00

FINISH TIME:

320°F

6X ϕ m/c 12/03/12

6 ϕ m/c ϕ 12/03/15

W/O:		WORK ORDER CHANGES					
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Work Order ID 80829

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Page 3

Item ID: D2573

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Aft Out 205

Stop *NS2*

Start Date: 01/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6 12-3-15

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

6 12-03-15

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/3/15

12-03-15

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-01-12 10:09:15 AM

Page 1

Work Order ID: 80829

80829

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 01/03/2012

Required Date: 21/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	83.0000	1	6			
D6101-007									**				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT042

78

79589 ✓

50

79875

28

MAT045

5

70680

3

76839

2

6

WZ 3-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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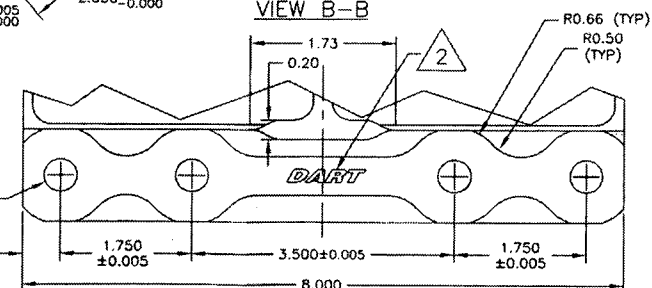
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	NEW ISSUE	
DS	PH	 DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO.	REV. E
		D2573	SHEET 1 OF 1
DATE	TITLE		
05.07.13	OUTER AFT SADDLE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD	Work Order: 80829
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.442	.442	.442		
B	1.745	1.755		1.748	1.748	1.749	1.749		
C	3.495	3.505		3.496	3.496	3.495	3.500		
D	1.745	1.755		1.750	1.752	1.752	1.747		
E	7.990	8.010		8.002	8.002	8.002	8.000		
F	0.490	0.510		.502	.506	.503	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.503	.507	.500	.503		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		.569	.570	.569	.572		
L	1.174	1.184		1.179	1.178	1.178	1.177		
M	1.365	1.375		1.369	1.370	1.370	1.377		
N	2.495	2.505		2.500	2.500	2.500	2.498		
O	4.119	4.129		4.122	4.123	4.123	4.124		
P	0.115	0.135		.128	.126	.126	.126		
Q	0.115	0.135		.132	.131	.131	.131		
R	0.240	0.260		.255	.254	.255	.256		
S	0.115	0.135		.130	.128	.127	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.225	3.225	3.225		
V	0.230	0.250		.235	.240	.240	.238		
W	0.115	0.135		.120	.125	.127	.128		
X	0.308	0.313		.310	.3095	.311	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.250	.249	.251		
AE	1.500	1.520		1.520	1.508	1.510	1.512		
AF	0.115	0.135		.131	.133	.133	.132		
AG	0.240	0.280		.259	.260	.260	.260		
AH	0.240	0.260		.251	.253	.252	.249		
AI	2.000	2.020		2.009	2.000	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>SP / R / JLM</i>	Audited by: <i>RL</i>
Date: 12/03/06	Date: reloshe

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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E	7.990	8.010		8.002	8.002				
F	0.490	0.510		0.5015	0.5015				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.377				
I	0.490	0.510		0.5005	0.5005				
J	1.174	1.184		1.128	1.179				
K	0.558	0.578		0.568	0.568				
L	1.174	1.184		1.178	1.180				
M	1.365	1.375		1.369	1.37				
N	2.495	2.505		2.499	2.5				
O	4.119	4.129		4.124	4.122				
P	0.115	0.135		.127	.126				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		.256	.254				
S	0.115	0.135		0.128	0.128				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.226	3.225				
V	0.230	0.250		0.243	0.242				
W	0.115	0.135		0.128	0.128				
X	0.308	0.313		.312	.312				
Y	0.760	0.765		.760	.761				
Z	0.352	0.372		0.364	0.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		0.254	0.253				
AE	1.500	1.520		1.516	1.506				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		.271	.265				
AH	0.240	0.260		0.254	0.254				
AI	2.000	2.020		2.008	2.001				
AJ	0.023	0.043							
Accept/Reject									

Measured by:	JJ Kex / m
Date:	12/03/06

Audited by:	Ch
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